

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011811**Date Inspected:** 06-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 5CW hold back welds green tag #6. The weld designations reviewed are as follows:

5BW+5CW

1. DP628-001-017,018
2. EP46-001-009,010
3. SP418-001-021,022,029,030
4. SP472-001-029,030,041,042
5. SP750-001-027,028,035,036
6. SP147-001-025,026,034,035
7. SP120-001-025,026,035,036
8. SP93-001-029,030,041,042
9. SP411-001-021,022,029,030

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- 10. DP622-001-013,014,017,018
- 12. EP39-001-009,010
- 13. BP139-001-027,028
- 14. BP46-001-027,028
- 15. BP-85-001-029,030

7BW+7CW

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBW7C side plate splice on counter weight side of segment. Welder is identified as Mr. Pan Meng (066673). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-T.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBW7C side plate splice on counter weight side of segment. Welder is identified as Mr. Yu Huiye (045143). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233-T.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at OBW7A edge plate weld splice on counter weight side of segment. Welder is identified as Mr. Pan Meng (066673). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBW7 deck plate splice on counter weight side of segment. Welder is identified as Mr. Jiang Yongsheng (045240). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 008 located at OBW7 deck plate splice on counter weight side of segment. Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Flux Core Arc Welding (FCAW) welding was performed on weld joint 007 located at OBW7 deck plate splice on counter weight side of segment. Welder is identified as Mr. Wang Quanlin (066746). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-223(2)1T-2.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. ZPMC worker was observed removing the hold back weldment on two (2ea) I ribs located on edge plate at cross beam side of segment for misalignment purpose per WR10663.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
